



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 201221



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		10/25/19	0.00	0.65	Skidtubes - Bend		MAC
120	Skidtubes - 2 - B4B	1 pcs		10/25/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		MBG
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		10/25/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S227929



Part: D205-634-041

Job No: 201221

Serial No/Batch: S227929

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96 - 88 Issue 2, FAA-STD SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

140 Skidtubes - 3 - B4B	1 pcs	10/25/19	0.00 3.00	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MCL
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	10/25/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	10/25/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/25/19	0.00 1.31	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 22 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 -	

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					B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
180	Powdercoat - 1 White GI(A)-B4B	1 pcs	10/25/19	0.00 0.34	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
190	QC 3	1 pcs	10/25/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
200	Handfinish - 4-1-Assembly-B4B	1 pcs	10/25/19	0.00 1.00	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	

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DAS
15
9-89

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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
225 DC - 1 - B4B	1	10/25/19	0.00 0.00	DC - 1 - B4B	DAS 21 NOV 28 2019
	pcs			DC - 2 - B4B	8-59
230 QC 21 - FG	1	10/25/19	0.00 0.00	QC 21 - FG - 21	DAS 21 NOV 28 2019
	pcs			QC 21 - FG - 70	8-59
				QC 21 - FG - 53	8-59

Part Op 110 - Skid tubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube

120 - Skid tubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skid tubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss (Ref 4.3.5.1) per QSI005 4.3 Alum START TIME: 8:05 OVEN TEMPERATURE: 320°

FINISH TIME: 8:35 11/21/86

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5231046 Sikaflex expire date: 20-3-18 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 20-3-18 Sikaflex expire date: 5231046 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5229693

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	013105
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5214193
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	5177095
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	3184047
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5209190
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5216385
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5217812
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5229062
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5045947
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5222906
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5207800
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208675
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5208809
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5225629
				5178378

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	11	0
140-Skidtubes - 3 - B4B	D2576-3	1	70	0
	D4202-1	20	700	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,502	0
	AN3-5A	2	272	0
	AN3C4A	50	484	0
	D2594-1	16	59	0
	D2594-3	16	466	0
	D2855	1	78	0
	D3564-11	1	9	0
	D3564-13	1	26	0
	D3564-5	1	19	0
	D3564-9	1	18	0
	NAS1149C0332R	50	2,501	0
	NAS1149D0332J	2	1,766	0
Part Specifications				
Specifications could not be found.				

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ITEM	QTY -341	QTY -345	QTY -347	QTY -348	DESCRIPTION
1	X				SKOTUBE ASSEMBLY
2		X			SKOTUBE ASSEMBLY
3			X		SKOTUBE ASSEMBLY
4				X	SKOTUBE ASSEMBLY
20	1	1	1	1	EXTRUSION
21			18	18	BUSHING
22	1	1	1	1	STEP
23		4			SPACER
24	18	18	8	8	PLUG
25	18	18	8	8	O-RING
26	1	1	1	1	200 WEB
27	1	1	1	1	AFT CAP
28	1	1	1	1	WEARSHOE
29	1	1	1	1	WEARSHOE
30	1	1	1	1	WEARSHOE
31	1	1	1	1	WEARSHOE
32	20	20	24	24	SPACER
33			1	1	WEARPLATE ASSEMBLY
34			1	1	WEARPLATE ASSEMBLY
35			1	1	PHD WEARPLATE
36			1	1	AFT WEARPLATE
50	50	50			INSERT
51	50	50			AL57-1032-130
52	2	2	2	2	or AK57-1032-130
53					or AK57-1032-130
54	50	50			or AK57-1032-130
55	2	2	2	2	or AK57-1032-130
56			8	8	or AK57-1032-130
57	2	2	2	2	AN5A
58			8	8	AN5A
59	50	50			WASHER (AN500104)
60	2	2	2	2	WASHER (AN500104)
61			8	8	NUT (OR M521042-4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2880 WEB
POWDER COAT (JANUARY 1998) GLOSS WHITE (REF 43.1.1) PER DART QSI 005 4.3
BLACK ANTI-SEED PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 005 4.1 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2880-041 = 33.7 lbs
D2880-045 = 33.7 lbs
D2880-047 = 48.1 lbs
D2880-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2880 WEB TO LOCATION SHOWN OFF AFT END OF SKOTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 018 BEFORE
BENDING. ENSURE HOLE LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 90 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTR17 & DTR17 ONLY FOR D2880-041-045 TO LOCATE AND DRILL
Ø0.397 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B,B AND F,F (60
PLACES) AFTER FINISH. INSTALL AN50A BOLTS AND NUTS 1400032R WASHERS WITH
SIKAFLEX-241-291.
- 12) INSERT D2880-1 PLUG CW D2880-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER
FINISH (10 PLACES FOR D2880-041-045 AND 8 PLACES FOR D2880-047-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2880 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

H	SHEET: PL DELETE D2880-14-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER DSI 8008	AJS	14.04.09
F	INCORPORATE DED D2880-E-1 PER PART12-218	DC	13.06.20
E	ADD D2880-047 (2N C4-7) AND D2880-7 (2N B3-9) INCLUDED DED D2880-0-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR17 & DTR17 WAS T02877-208 (2N C4-1)	RF	11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS, INCLUDE DED 5124/8103	PH	07.04.06
C	REDRAWN, INCLUDED DED 0094/ 8097	CP	08.08.26
B	AS MANUFACTURED	DS	08.12.02
A	NEW ISSUE	DS	09.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	REV. H		
INFO. APPR.	DRAWING NO.		
APPROVED	D25580		
DE APPR.	TITLE		
DATE	205 SKOTUBE ASSEMBLY		
	SCALE		
	NTS		
	17.06.09		

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WORK ORDER

201222 M5

19-01-27

RELEASED

2017 JUL 05

early-stm

DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA	
REV. H	SHEET 1 OF 9
205 SKOTUBE ASSEMBLY	SCALE
NTS	



DESIGN	DS	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO.	REV. H
CHECKED	<i>WZ</i>	D2560	SHEET 3 OF 9
MFG. APPR.	<i>WZ</i>	TITLE	SCALE
APPROVED	<i>WZ</i>	209 SKIDTUBE ASSEMBLY	NT85
DE APPR.	<i>WZ</i>	CONFIDENTIAL © 1984 BY DART AEROSPACE LTD	
DATE	17.06.08	THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE KEPT IN THE COMPANY'S FILES & IS NOT TO BE REPRODUCED OR USED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



2017 JUL 05 402
RELEASED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2580	SHEET 5 OF 8
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	205 SKIDTUBIE ASSEMBLY	MTB
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1988 BY DART AEROSPACE LTD	
DATE	17.06.08	THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE MANUFACTURE OF THE PARTS AND ASSEMBLIES SPECIFIED THEREON. IT IS NOT TO BE REPRODUCED OR USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Engineering ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																																																																									
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____																																																																									
Description Work Order Deviation				Disposition																																																																											
Root Cause <table border="1"> <tr> <td>Operator</td><td>☐</td> </tr> <tr> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> </tr> <tr> <td>Handling/Preservation</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> </tr> <tr> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Human Factors</td><td>☐</td> </tr> </table>				Operator	☐	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Bending</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Tolerance</td><td>☐</td> </tr> <tr> <td>Crushing</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain Direction</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td><td>☐</td> <td>Incomplete/Unclear Instructions</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Mislaabeled</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Off-set/Set-up</td><td>☐</td> <td></td><td></td> </tr> </table>				Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislaabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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Other/Details: _____																																																																															
Completed By				Lead hand / Supervisor																																																																											
QC / QA Coordinator																																																																															